

Work Order ID 123073

\*123073\*

Page 1

\* Tuesday, July 29, 2014 2:29:55 PM

Item ID: D3552-11 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Door Prop  
 Start Date: 7/29/14 Start Qty: 12.00 \*12\* Cust Item ID:  
 Required Date: 7/29/14 Req'd Qty: 12.00 \*12\* Customer:  
 Reference:

Approvals: Process Plan: J.A Date: 14/07/30 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3552    | K            |

100 0.00

\*100\*

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 25697  
 Purchase Part Number: B8-240-575-150N  
 Supplier: LS Technologies  
 Certificate of conformity is required

0.00

CL 14/09/09 12

110

Receive & Inspect for Damage & Mat'l Certs 0.00

\*110\*

Packaging

Packaging

Memo

Ensure certificate of conformity is attached

0.00

14/7/11 (12)

120

QC6- Inspect dimensions to drawing 0.00

\*120\*

QC

Quality Control

Memo

Test for correct pressure

0.00

(12) DAS 38 9-80 14-10-3

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|  |  |  |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>   | Water Jet <input type="checkbox"/>   | Engineering <input type="checkbox"/> |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>   | Prod. Eng. Coord. <input type="checkbox"/>   | Quality <input type="checkbox"/>     |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Thermoforming <input type="checkbox"/>                       | Finishing <input type="checkbox"/>   | Rec/Store/Packaging <input type="checkbox"/>   | Other <input type="checkbox"/>       |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>   | Supplier <input type="checkbox"/>  |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |

| Root Cause    | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design        |      |      |     |   |                   |                    |             |              |              |
| Doc/Data      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling |      |      |     |   |                   |                    |             |              |              |
| Handling/Pre  |      |      |     |   |                   |                    |             |              |              |
| Material      |      |      |     |   |                   |                    |             |              |              |
| Operator      |      |      |     |   |                   |                    |             |              |              |
| Offset/Setup  |      |      |     |   |                   |                    |             |              |              |
| Process       |      |      |     |   |                   |                    |             |              |              |
| Supplier      |      |      |     |   |                   |                    |             |              |              |
| Training      |      |      |     |   |                   |                    |             |              |              |
| Transport     |      |      |     |   |                   |                    |             |              |              |
| Unapproved    |      |      |     |   |                   |                    |             |              |              |

### FAULT CATEGORY

|  |  |   |  |
|--|--|---|--|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crimp/Kink/Ripple/Wave<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Crushing<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Marks/Chatter<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damage/Defect<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program<br><input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete/Unqualified<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Misaligned/off center<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Off-set<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Set-up<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><br><input type="checkbox"/> Other |
|--|--|---|--|

**Work Order ID 123073**

Tuesday, July 29, 2014 2:29:55 PM

**\*123073\***

Page 2

Item ID: D3552-11

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Door Prop

Start Date: 7/29/14 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 7/29/14 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                            | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130                            | Identify as per dwg & Stock Location: <b>St 363</b> | 0.00                 |         |        |              |               |               |                  |                |
| <b>*130*</b>                   |   |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo  | 0.00                 |         |        |              | DAS           |               | OCT 03 2014      |                |
| Packaging                      |   |                      |         |        |              | 06            |               |                  |                |
|                                |   |                      |         |        |              | 9-89          |               |                  |                |
| 140                            | QC21- Final Inspection - Work Order Release         | 0.00                 |         |        |              |               |               |                  |                |
| <b>*140*</b>                   |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |

MLJ 14-10-06

4-10-03

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|  |  |  |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>   | Water Jet <input type="checkbox"/>   | Engineering <input type="checkbox"/> |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>   | Prod. Eng. Coord. <input type="checkbox"/>   | Quality <input type="checkbox"/>     |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Thermoforming <input type="checkbox"/>                       | Finishing <input type="checkbox"/>   | Rec/Store/Packaging <input type="checkbox"/>   | Other <input type="checkbox"/>       |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>   | Supplier <input type="checkbox"/>  |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |

| Root Cause    | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design        |      |      |     |   |                   |                    |             |              |              |
| Doc/Data      |      |      |     |   |                   |                    |             |              |              |
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| Handling/Pre  |      |      |     |   |                   |                    |             |              |              |
| Material      |      |      |     |   |                   |                    |             |              |              |
| Operator      |      |      |     |   |                   |                    |             |              |              |
| Offset/Setup  |      |      |     |   |                   |                    |             |              |              |
| Process       |      |      |     |   |                   |                    |             |              |              |
| Supplier      |      |      |     |   |                   |                    |             |              |              |
| Training      |      |      |     |   |                   |                    |             |              |              |
| Transport     |      |      |     |   |                   |                    |             |              |              |
| Unapproved    |      |      |     |   |                   |                    |             |              |              |

### FAULT CATEGORY

|  |  |   |
|--|--|---|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crimp/Kink/Ripple/Wave<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Crushing<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Marks/Chatter<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damage/Defect<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program<br><input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete/Unqualified<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Misaligned/off center<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Off-set<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence |
|  |  | <input type="checkbox"/> Outside Dimensions<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge  |
|  |  | <input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Set-up<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Other  |

# Picklist Print

Tuesday, July 29, 2014 2:29:55 PM

Page 1

Work Order ID: 123073

\*123073\*

Parent Item: D3552-11

\*D3552-11\*

Parent Item Name: Door Prop

Start Date: 7/29/14

Required Date: 7/29/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:B 09-04-20 rev.d as per dwg DD verified by:EC IPP Rev:C  
as per dwg RevE DD 10.02.17 verified by:EC IPP Rev:D 10.12.03 as  
per dwg rev.G DD verf:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

B8-240-575-150N

Purchased

No

110

Each

0.0000

1

12

\*B8-240-575-150N\*

\*\*

GAS SPRING

*7/29/14 (12)*

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

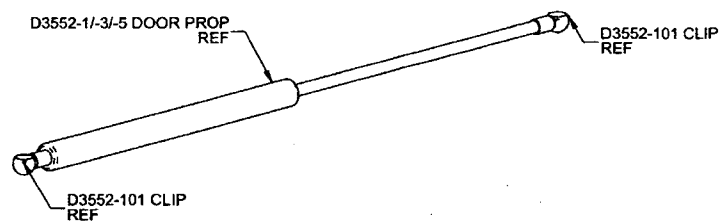
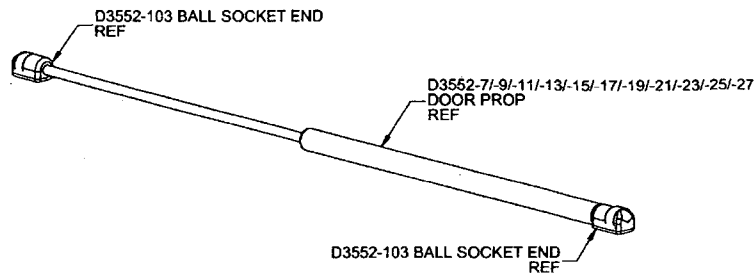
|  |  |   |
|--|--|---|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |
|--|--|---|

| Root Cause    | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design        |      |      |     |   |                   |                    |             |              |              |
| Doc/Data      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling |      |      |     |   |                   |                    |             |              |              |
| Handling/Pre  |      |      |     |   |                   |                    |             |              |              |
| Material      |      |      |     |   |                   |                    |             |              |              |
| Operator      |      |      |     |   |                   |                    |             |              |              |
| Offset/Setup  |      |      |     |   |                   |                    |             |              |              |
| Process       |      |      |     |   |                   |                    |             |              |              |
| Supplier      |      |      |     |   |                   |                    |             |              |              |
| Training      |      |      |     |   |                   |                    |             |              |              |
| Transport     |      |      |     |   |                   |                    |             |              |              |
| Unapproved    |      |      |     |   |                   |                    |             |              |              |

### FAULT CATEGORY

|  |  |   |  |
|--|--|---|--|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crimp/Kink/Ripple/Wave<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Crushing<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Marks/Chatter<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damage/Defect<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program<br><input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete/Unqualified<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Misaligned/off center<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Off-set<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Set-up<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Other |
|--|--|---|--|

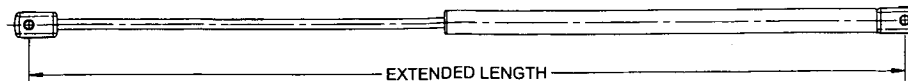
# SPECIFICATION CONTROL DRAWING



**RELEASED**  
2012-07-24

J.A 14/07/30 123073

|            |   |  |              |
|------------|---|--|--------------|
| K          | ADD "X" TO LS TECHNOLOGIES P/Ns TO DESIGNATE "EXTRA DAMPING" FOR D3552-15/-17/-19/-25/-27. REASON: PART2-209.   | MB   | 12.07.16     |
| J          | ADD P/N D3552-25/-27. REMOVE ALTERNATE PART NUMBER FOR -15, -17 AND -19. STROKE FOR -15, -17 AND -19 WAS 139/5.06 NOW 154/6.06. EXTENDED LENGTH FOR -15, -17 AND -19 WAS 386/15.2 NOW 387/15.2.                 | AP   | 11.12.07     |
| I          | ADD P/N D3552-23  | RF   | 11.10.11     |
| H          | ADD P/N D3552-21  | DC   | 11.03.10     |
| G          | FOR -15, FORCE:300/87.4 WAS 400/89.9, SUPPLIER P/N B8-154-387-300N WAS B8-154-387-400N; FOR -17, STROKE: 139/5.47 WAS 160/6.30, EXT LG: 386/15.2 WAS 407/16.0, SUPPLIER P/N B8-154-387-150N WAS B8-167-408-150N | JPH  | 10.11.01     |
| F          | ADD P/N D3552-15/-17/-19 AND ALTERNATE SUPPLIER   | JPH  | 10.07.27     |
| E          | ADD P/N D3552-13 ZN B8-1, A8-1, D6-1. CHANGE NAME FROM "GAS SPRING" TO "DOOR PROP" THROUGH OUT DWG  | HS   | 10.02.03     |
| D          | ADD P/N D3552-101 ZN D6-1, C7-1, C1-1 AND D3552-103 ZN D1-1 AND C2-1 AND ZN B8-1; ADD NOTE REGARDING D3552-101 AND D3552-103 COMPATIBILITY ZN A8-1  | HS   | 09.04.02     |
| C          | ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7   | LE   | 07.08.01     |
| B          | ADD D3552-7/-9; UPDATE DESC. D3552-1/-3/-5  | LE   | 06.10.24     |
| A          | NEW ISSUE   | LE   | 06.09.15     |
| REV.       | DESCRIPTION   | BY   | DATE         |
| DESIGN     | JE  | <div>DART AEROSPACE LTD<br/>HAWKESBURY, ONTARIO, CANADA</div> <div>DRAWING NO. D3552</div> <div>TITLE DOOR PROP</div> <div>DATE 12.07.16</div> <div>COPYRIGHT © 2006 BY DART AEROSPACE LTD</div> <div><small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small></div> |              |
| DRAWN      | JE  |  |              |
| CHECKED    | JE  |  |              |
| MFG. APPR. | JE  |  |              |
| APPROVED   | JE  |  |              |
| DE APPR.   | JE  | DRAWING NO. D3552  | REV. K       |
| DATE       | 12.07.16  | TITLE DOOR PROP  | SHEET 1 OF 2 |
|            |   |  | SCALE NTS    |



| DART PART NUMBER | DESCRIPTION               | STROKE (mm/in) | EXTENDED LENGTH (mm/in) | FORCE (N/lb) | END FITTING            | MATERIAL     | SUPPLIER        | SUPPLIER PART NUMBER OR MODEL NUMBER |
|------------------|---------------------------|----------------|-------------------------|--------------|------------------------|--------------|-----------------|--------------------------------------|
| D3552-1          | DOOR PROP                 | 220/8.66       | 530/20.6                | 70/15.7      | 10mm SS BALL SOCKET    | CARBON STEEL | LS TECHNOLOGIES | C8-220-530-070N                      |
| D3552-3          | DOOR PROP                 | 200/7.87       | 490/19.3                | 200/45.0     | 10mm SS BALL SOCKET    | CARBON STEEL | LS TECHNOLOGIES | C8-200-490-200N                      |
| D3552-5          | DOOR PROP                 | 175/6.89       | 430/16.9                | 150/33.7     | 10mm SS BALL SOCKET    | CARBON STEEL | LS TECHNOLOGIES | C8-175-430-150N                      |
| D3552-7          | DOOR PROP                 | 220/8.66       | 530/20.9                | 70/15.7      | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B8-220-530-070N                      |
| D3552-9          | DOOR PROP                 | 200/7.87       | 490/19.3                | 200/45.0     | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B8-200-490-200N                      |
| D3552-11         | DOOR PROP                 | 240/9.45       | 575/22.6                | 150/33.7     | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B8-240-575-150N                      |
| D3552-13         | DOOR PROP                 | 220/8.66       | 530/20.9                | 140/31.5     | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B6-220-530-140N                      |
| D3552-15         | DOOR PROP W/EXTRA DAMPING | 154/6.06       | 387/15.2                | 300/67.4     | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B8-154-387-300NX                     |
| D3552-17         | DOOR PROP W/EXTRA DAMPING | 154/6.06       | 387/15.2                | 156/35.1     | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B8-154-387-156NX                     |
| D3552-19         | DOOR PROP W/EXTRA DAMPING | 154/6.06       | 387/15.2                | 60/13.5      | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B8-154-387-060NX                     |
| D3552-21         | DOOR PROP                 | 167/6.57       | 410/16.1                | 70/15.7      | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B6-167-410-070N                      |
| D3552-23         | DOOR PROP                 | 190/7.48       | 475/18.7                | 70/15.7      | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B6-190-475-070N                      |
| D3552-25         | DOOR PROP W/EXTRA DAMPING | 148/5.83       | 475/18.7                | 300/67.4     | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B8-148-475-300NX                     |
| D3552-27         | DOOR PROP W/EXTRA DAMPING | 148/5.83       | 475/18.7                | 156/35.1     | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B8-148-475-156NX                     |
| 2 D3552-101      | CLIP                      | N/A            | N/A                     | N/A          | N/A                    | CARBON STEEL | LS TECHNOLOGIES | C9                                   |
| 3 D3552-103      | BALL SOCKET END           | N/A            | N/A                     | N/A          | N/A                    | NYLON        | LS TECHNOLOGIES | B10                                  |

### D3552-X DOOR PROP

**RELEASED**  
2012-07-24

#### NOTES:

- 1) IDENTIFICATION: IDENTIFY PER QSI 044 6.2
- 2) D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-1/-3/-5 DOOR PROPS
- 3) D3552-103 BALL SOCKET END IS ONLY COMPATIBLE WITH D3552-7/-9/-11/-13/-15/-17/-19/-21/-23/-25/-27 DOOR PROPS

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | DE       | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      | JP       | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    | AS       | DRAWING NO. <b>D3552</b>   | REV. K       |
| MFG. APPR. | TH       |  | SHEET 2 OF 2 |
| APPROVED   |          | TITLE <b>DOOR PROP</b>   | SCALE NTS    |
| DE APPR.   |          |  |              |
| DATE       | 12.07.16 | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO25697**

Purchase Order Date 9/9/2014

PO Print Date 9/9/2014

Page Number 1 of 1

**Order From :**

VC-LST0001

**Ship To :** DART AEROSPACE LTD

LS TECHNOLOGIES INC.  
314 JESSOP AVE  
SASKATOON, SK S7N 1Y6  
CA

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAKED**

**Contact Name**

**Vendor Phone** 306 683 5000

**Ship To Contact**

**Ship To Phone**

**Ship Via:** FedEx Overnight collect

**Ship Acct:**

**Buyer**

Chantal Lavoie

**Customer POID**

**Customer Tax #** 10127-2607

**Terms** Net 30

**Currency** CAD

**FOB** EXW - (Ex Works)

| Line Nbr    | Reference Vendor Part Number<br>Line Comments<br>Delivery Comments  | Description/<br>Mfg ID         | Req Date/<br>Taxable<br>Promise Date | CD | Req Qty/<br>Unit of<br>Measure | PO Unit Price | Extended Price |
|-------------|---|--------------------------------|--------------------------------------|----|--------------------------------|---------------|----------------|
| 1           | B8-240-575-150N<br><br>AS PER DWG D3552-11 REV. K<br>B123073  | GAS SPRING                     | 9/12/2014<br>Yes<br>9/12/2014        |    | 12.00<br>Each                  | \$41.36       | \$496.37       |
| Line Total: |   |                                |                                      |    |                                |               | \$496.37       |
| 2           | 71401-45<br><br>Procurement Quality Clauses<br>A004 faa-pma/tso<br>A005 right of entry<br>A016 personnel qualification<br>A025 certification of conformance<br>A040 notification of quality escape<br>A043 retention of quality documents | PROCUREMENT<br>QUALITY CLAUSES | 9/12/2014<br><br>No<br>9/12/2014     |    | 1.00                           | \$0.00        | \$0.00         |
| Line Total: |   |                                |                                      |    |                                |               | \$0.00         |
| PO Total:   |   |                                |                                      |    |                                |               | \$496.37       |

**PO Instructions:** Fedex Acc#151793240

**Note:** Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

**Change Nbr:** 1

**Change Date:** 9/9/2014

Ph # (306) 683-5000

|          |           |           |
|----------|-----------|-----------|
| P.O. No. | Date      | Invoice # |
| 25697    | 9/10/2014 | 11707     |

| Name / Address  |
|---|
| Dart Aerospace Ltd<br>1270 Aberdeen St.<br>Hawkesbury, ON K6A 1K7 |

|   |
|---|
| Ship To   |
| Main Finished Goods Location<br>Dart Aerospace Ltd<br>1270 Aberdeen St.<br>Hawkesbury, ON K6A 1K7 |

|           |        |     |
|-----------|--------|-----|
| Ship      | Via    | FOB |
| 9/10/2014 | Fed-Ex |     |

| Qty   | Description                 |
|---|-----------------------------|
| 12  | D3552-11 B123073 Gas Spring |
| Shipping Via FED EX Tracking # 771106116884 |                             |



LS Technologies Inc  
314 Jessop Ave  
Saskatoon, SK, S7N 1Y6  
Ph: (306) 683-5000 Fax: (306) 683-6403

### **Certificate of Compliance**

This is to certify that the parts listed below meets specifications as required by your order.  
May 2, 2014

**12 Units: D3552-11 B123073 Carbon Steel Gas Spring**

**Country of Manufacture: Canada**  
**Date of Manufacture : September 2014**  
**This product is ROHS compliant.**

Purchase Order # 25697  
Invoice # 11707

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to be 'Nolan Fehr', written over a horizontal line.

Nolan Fehr  
Manager